

Date: Monday, 28/05/2007 9:10:38 AM
User: Linda Lacelle

ASAP

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BASKET HINGE
Job Number :	32407		
Estimate Number :	10904		
P.O. Number :	N/A	Part Number :	D33283
This Issue :	28/05/2007	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D3328 REV B
First Issue :	N/A	Project Number :	N/A
Previous Run :	32407	Drawing Revision :	B
	Type :	Material :	N/A
	SMALL /MED FAB	Due Date :	04/06/2007
Written By :			Qty: 10 Um: Each
Checked & Approved By :			
Comment :	Est. A 05.02.09 New issue KJ/JLM Est Rev:B Now on Waterjet 07-05-28 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S125	1010-1025 sheet .125
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Comment: Qty.: 0.0729 sf(s)/Unit Total : 0.7287 sf(s)
1010-1025 sheet .125
Batch: M103840 ml 070529 (10)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D3382
Dwg Rev: B ml 070529 (10)
Prog Rev: B

2-Deburr if necessary mf 07-05-29 (10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE ml 070529 (10)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK 07/05/29 (10)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: WS 07/05/29 (10)

Date: Monday, 28/05/2007 9:10:38 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET HINGE

Job Number: 32407

Part Number: D33283

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10
28/05/30

Job Completion



U 28/05/30

Date: Wednesday, 5/16/2007 1:40:52 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BASKET HINGE
 Job Number : 32407
 Estimate Number : 10904
 P.O. Number :
 This Issue : 5/16/2007 S.O. No. :
 Prsht Rev. : NC Part Number : D33283
 First Issue : / / Type : PURCHASED PARTS Drawing Number : D3328 REV B
 Previous Run : Project Number : N/A
 Material :
 Due Date : 5/30/2007 Qty: 10 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est. A 05.02.09 New issue KJJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: _____

Email or Ship DXF file to vendor

Laser Cut flat pattern per Dwg D3328

Possible Supplier: Industrial Laser

Material release note is required

1090429
 06957

WZ target

2.0 D33283F Basket Hinge



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Basket Hinge

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 1:40:52 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET HINGE

Job Number: 32407

Part Number: D33283

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

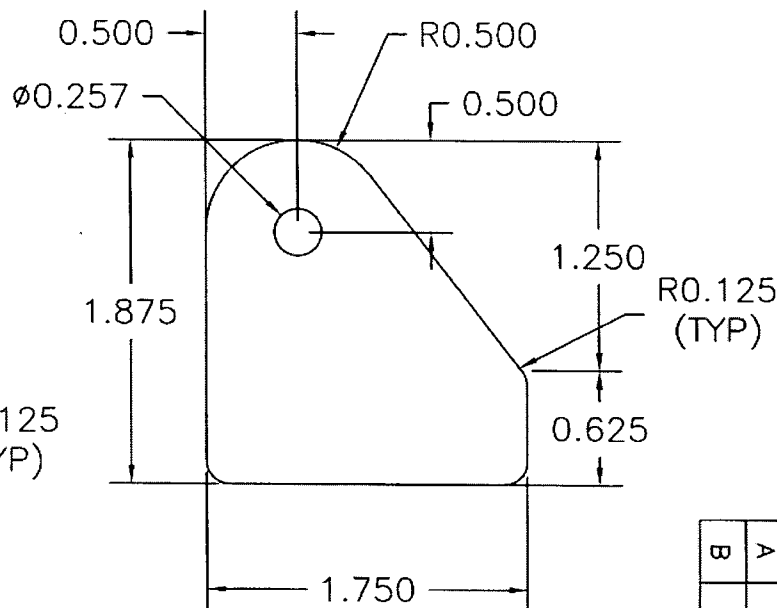
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

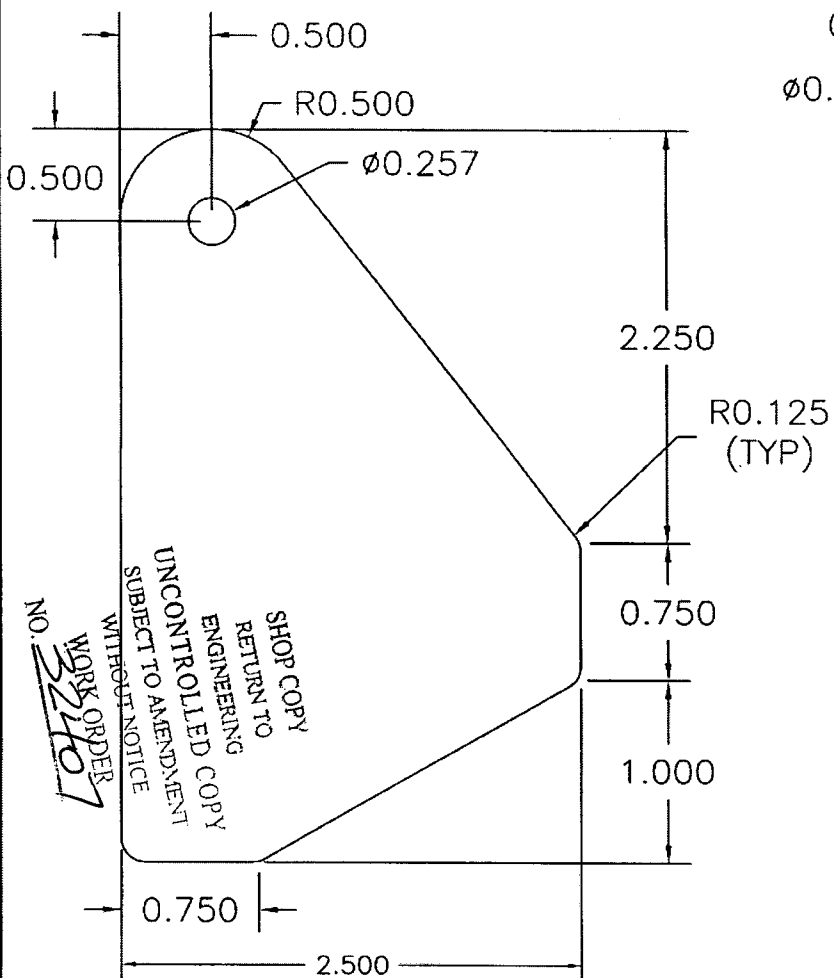


DESIGN		DRAWN BY		DART AEROSPACE LTD	
01		01		HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO.	
01		01		D3328	
DATE		TITLE		SHEET 1 OF 1	
05.04.25		BASKET HINGE		SCALE	
A		04.10.27		NEW ISSUE	
B		05.04.25		-1, HEIGHT DECREASED BY 0.125	

RELEASED
15.04.28



D3328-1



D3328-3

D3328-1/-3 BASKET HINGE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.120 THICK) (DART REF. M1010S-S10GA)
- 2) BREAK ALL SHARP EDGES TO 0.005 TO 0.015
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32401

DART AEROSPACE LTD		Work Order: 32401
Description: Bearpaw Basket Hinge		Part Number: D 3328-3
Inspection Dwg: D 3328 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	Ø 0.251	+0.006 - 0.001	0.251	✓		vern	
B	0.750	+/- 0.010	0.750	✓		vern	
C	0.500	+/- 0.010	0.500	✓		vern	
D	0.500	+/- 0.010	0.500	✓		vern	
E	4.000	+/- 0.010	4.006	✓		vern	
F							
G							
H							
I							
J							
K							
L							
M							
N							
O							
P							
Q							
R							
S							
T							
U							
V							
W							
X							
Y							

Measured by: ml - MM	Audited by: AS	Prototype Approval:	N/A
Date: 07/05/21	Date: 07/05/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	KJ/RF	